

Work Order ID 60291

July 1, 2010 11:44:21 AM

Page 1

Item ID: D3121-141

Accept

Setup

Start

Revision ID:

Item Name: Bracket Assembly

Stop

Start Date: 02/07/2010 Start Qty: 12.00

Cust Item ID:

Required Date: 29/07/2010 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3121

Rev E

100

0.00



BAND SAW

Bandsaw

Memo

*0.00

Jeaspa Bandsaw

Cut blanks: (1.250" x 2.000") 6.600" long

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine D3121-111 as per Folio FA361 and Dwg D3121 Identify as D3121-111 □2-Deburr □3-Scribe batch number

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

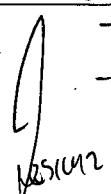
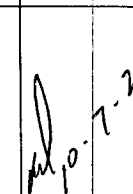
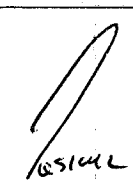
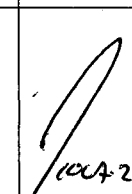
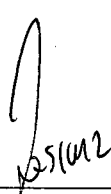

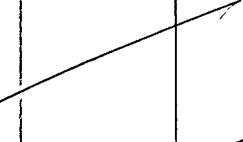
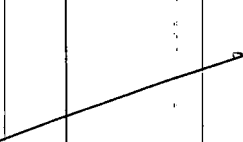

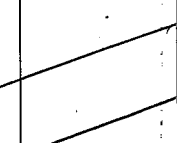
Quality Control

Pro

Dart Aerospace Ltd

W/O: 60291		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3121-141 PAR #: _____ Fault Category: machining NCR: Yes No DQA: _____ Date: 10-08-05
 Resolution: SCVAP Disposition: Scrap QA: N/C Closed: Yes Date: 10/08/06

NCR: 60291		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.7.20	120	- spigot undersize (.392 ^{+1.002} _{-.000}) - actual size .386 - collet interferes with inside of holder where there is a plug. leaving		- scrap + Replace - Remove plug from inside tool holder.		H.A. 10/07/22		
		the tool .008" Total Indicator Runout. R.C. process.						
				w/o 60291				

NOTE: Date & initial all entries

Work Order ID 60291

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Page 2

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Customer:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

B.A 10/07/22

12

0

Quality Control

140

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Assemble D3121-141 as per Dwg D3121.

5/10/07/27 (12)

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

5/10/27

(12)

Quality Control

Work Order ID 60291

July 1, 2010 11:44:21 AM



Page 3

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Identify as per dwg & Stock Location: **235A**

0.00



Packaging

Memo

0.00

Packaging

10-7-27 SP

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/28 JF
10-7-27 (12)

Picklist Print

July 1, 2010 11:44:21 AM

Page 1

Work Order ID: 60291

Parent Item: D3121-141

Parent Item Name: Bracket Assembly

Start Date: 02/07/2010

Required Date: 29/07/2010

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP Rev:Pick:A04.02.18New issueKJ/DS

IPP Rev:B ECN 1060 07-11-12 DD verified by: EC

IPP Rev:C New Dimensions for Blank Size 08-07-23 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3121-21 Bolt		Manufactured	No			140	Each	31.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235				31					
				57376				1					
				59044				30					
D3121-241 Bearing Assembly		Manufactured	No			100	Each	8.0000	1	12			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST235B				8					
				55005				2					
				59774				6					
M174B1.250X02.000 17-4 SS Bar 1.250 x 2.00		Purchased	No			140	f	12.0000	0.55	6.947368			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT				12					
				114899				12					

6/5/07/27

6/5/07/27

359435 (124)

6.947 and 10/6/19
(+ .552 NCR REPLACEMENT)

DART AEROSPACE LTD		Work Order: 60291
Description: Bracket		Part Number: D3121-111
Inspection Dwg: D3121	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

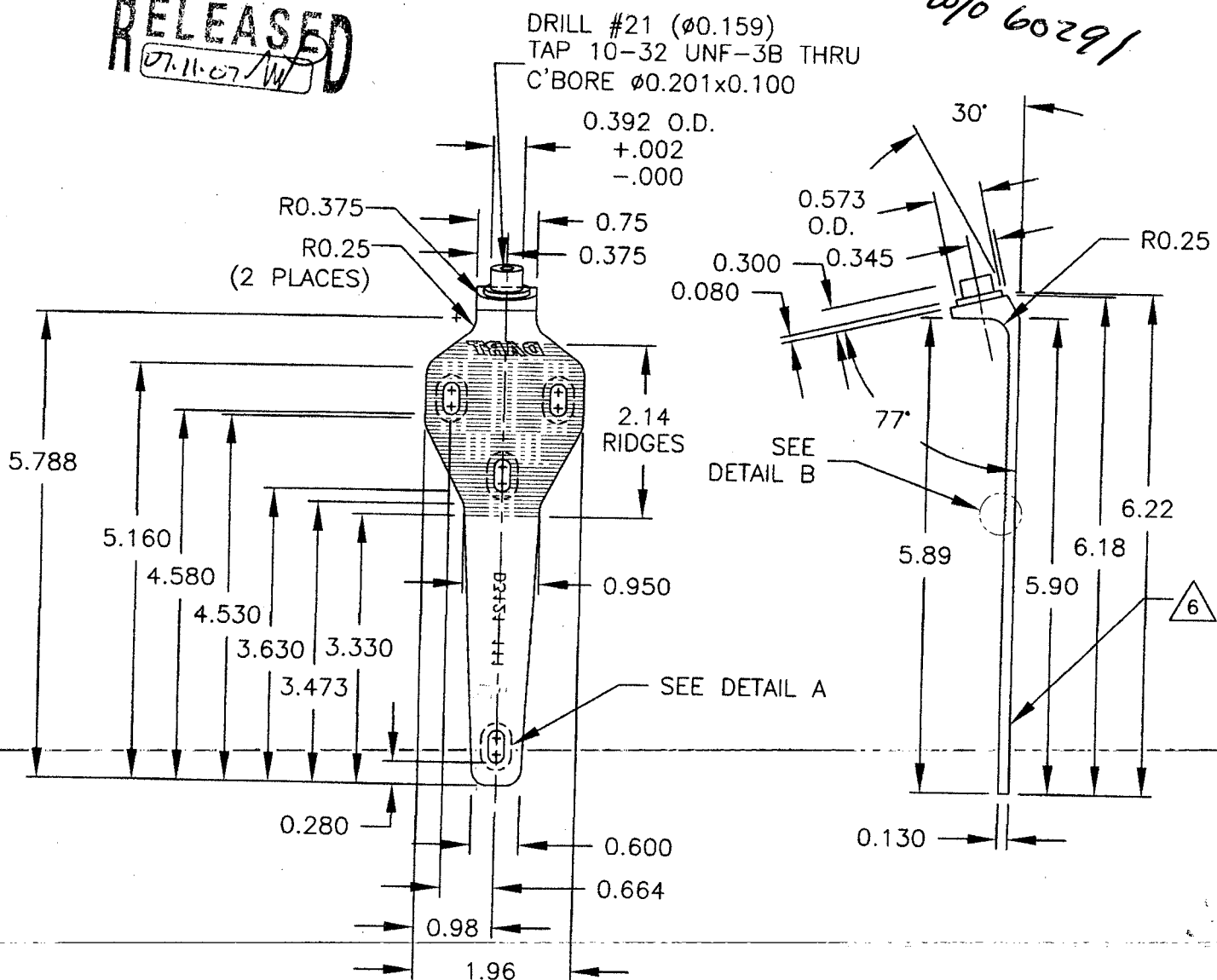
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.392	+0.002/-0.000	.393	/		Mic	
0.75	+/-0.030	.752	/		Vern	
0.375	+/-0.010	.375	/		"	
2.14	+/-0.030	2.140	/		"	
1.96	+/-0.030	1.967	/		"	
0.280	+/-0.010	.280	/		"	
3.330	+/-0.010	3.330	/		"	
3.630	+/-0.010	3.630	/		"	
R0.25	+/-0.030	R.25	/		"	
R0.375	+/-0.010	R.375	/		"	
Ø0.201	+0.005/-0.001	.201	/		"	
0.100	+/-0.010	.103	/		"	
4.580	+/-0.010	4.580	/		"	
6.18	+/-0.030	6.180	/		"	
5.89	+/-0.030	5.890	/		"	
0.080	+/-0.010	.080	/		"	
0.300	+/-0.010	.300	/		"	
30°	+/-0.1°	30°	/		Protractor	
R0.25	+/-0.030	R.25	/		Vern	
0.130	+/-0.010	.130	/		"	
0.664	+/-0.010	.664	/		"	
0.381	+/-0.010	.381	/		"	
0.201	+/-0.010	.201	/		"	
0.400	+/-0.010	.396	/		"	
0.580	+/-0.010	.585	/		"	
100°	+/-0.1°	100°	/		gauge	
0.032	+0.000/-0.010	.03	/		"	

Measured by: <i>[Signature]</i>	Audited by: <i>A.A</i>	Prototype Approval:	N/A
Date: 10-7-21	Date: 10/07/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.12	New Issue P/O D3121-141	KJ/RF	
B	04.05.05	Dimensions changed/re-arranged per Dwg revision	KJ/JLM	
C	06.06.14	Dwg Rev. updated	KJ/JLM	
D	08.01.16	Dimensions updated per Dwg Rev. E	KJ/EC/DD	
E	08.05.28	Tolerance revised for Ø0.201 dimension	KJ/DD	<i>[Signature]</i>

DART

DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 7 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:2

RELEASED
07.11.07/W**D3121-111 BRACKET**

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

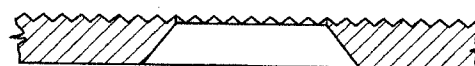
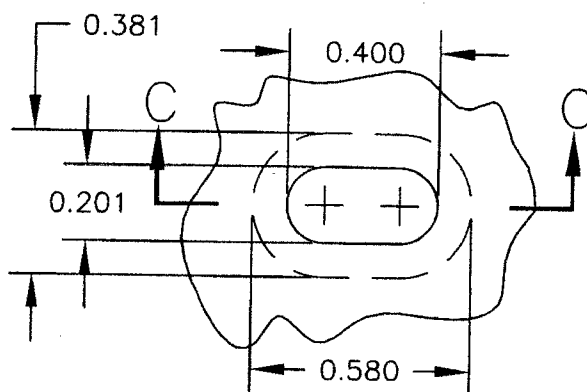
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DESIGN <i>[Signature]</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3121	REV. E SHEET 3 OF 10
DATE 07.11.07		TITLE BRACKET ASSEMBLY	SCALE 1:1

DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED

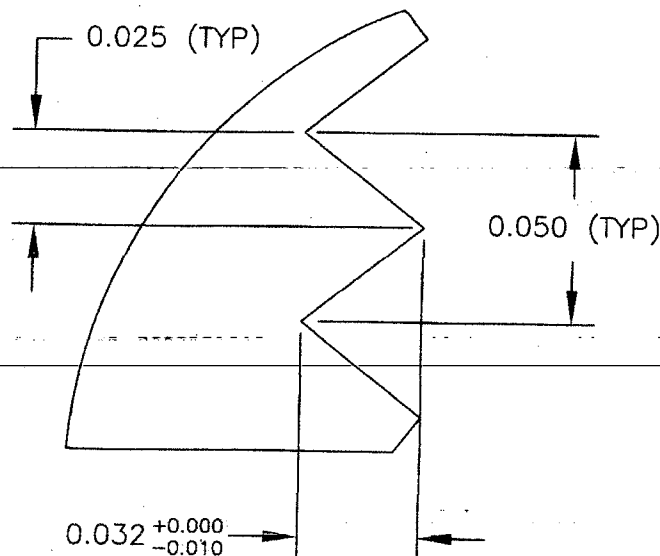


100° C'SINK

SECTION
C-C

RELEASED
07.11.07 *[Signature]*

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



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